DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-024155
Date Inspected: 31-May-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Mr. Shi Lei

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Segment

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3136-009~016-006 and 008 located on side plate connected SA3136 at panel point 123 to 123.5 FL2 side of OBG Segment 13CW. ZPMC Welders are identified as 045143 and 066734. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015K-211, 215, 213 and 216 located on Vertical RS stiffener to floor beam at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21024. .

SMAW welding of weld joint SEG3014D-306, 315, 340 located on side plate RS stiffener to floor beam at panel point 121 to 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 066156. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable

WPS-345-SMAW-3G-(3F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20164.

SMAW welding of weld joint SEG3014F-322, 327 and 317 located on side plate I-rib to floor beam at panel point 121 to 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 067947. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint AH3003-054 located on Architecture House side plate to Edge Plate at panel point 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 040270. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20719.

SMAW welding of weld joint SEG3013E-054 located on side plate RS stiffener to floor beam at panel point 1i9. 65 of OBG Segment 13AW. ZPMC Welder is identified as 066757. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013C-276 located on side plate RS stiffener to floor beam at panel point 120 of OBG Segment 13AW. ZPMC Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20604.

SMAW welding of weld joint SEG3013AH-136 located on Floor Beam RS stiffener to Grillage at panel point 119 of OBG Segment 13AW. ZPMC Welder is identified as 067904. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20967.

SMAW welding of weld joint SEG3020AV-006 and 011 located on SA3416 to floor beam at panel point 128.3 of OBG Segment 14W. ZPMC Welders are identified as 067572 and 066675. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G-(1F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21133. See the attached picture.

Visual Inspection after Blast – Trial Assembly Yard

OBG Segment 13AE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 13AW, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. The panel point is identified as PP118 to 119-1500 at counter weight side of OBG Segment 13AW. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

WELDING INSPECTION REPORT

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer